

Work Order ID 71069

Tuesday, June 21, 2011 2:34:13 PM

Page 1

Item ID: D4018-041

Revision ID:

Item Name: Short Basket Lid Assembly (350)

Start Date: 6/21/2011 Start Qty: 1.00

Required Date: 6/30/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4018

C

100

Weld per dwg A/R S.S. rod Batch: **M115788** 0.00

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

11.06.24

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.06.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71069

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Item ID:	D4018-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Short Basket Lid Assembly (350)				Stop	
Start Date:	6/21/2011	Start Qty:	1.00			
Required Date:	6/30/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	*** mask sides of hinge prior to powdercoat***								

M115128

Start Time: 1:15
Oven Temperature: 320 OF
Finish Time: 1:45

140	Wing Walk as per dwg QSI005 4.4 Batch 117863	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- install label								

IX D M / 11/06/27

1 BR 11-6-28.

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Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350)

Start Date: 6/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							<i>EP 4/06/28 ①</i>
160 	Identify as per dwg & Stock Location: <i>6-A</i>	0.00							
Packaging Packaging	Memo <i>w/o #1067</i>	0.00							<i>EP 11/06/28 ②</i>
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<i>n 16/29 *</i> <i>MF 11-06-28</i>

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Picklist Print

Tuesday, June 21, 2011 2:34:20 PM

Page 1

Work Order ID: 71069

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 6/21/2011


Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg
RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD
10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4018-1  Rib		Manufactured	No			100	Each	7.0000	2	2			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--


Location	Loc Qty	Loc Code
WA	2	
67039	2	
WA005	5	
68478	3	
69077	2	

SAD 11-06-22

✓ D4018-3  Rib		Manufactured	No			100	Each	12.0000	2	2			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA005	12	
63128	6	
68479	6	

SAD 11-06-22

✓ D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	16.0000	3	3			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	16	
69164	7	
69725	3	
70373	6	

SAD 11-06-22

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 71069

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 6/21/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No

100

Each

28.0000

6

6



Rib



SAD 11-06-22

Location

Loc Qty

Loc Code

WA005

28

67041

14

70337

14

D4035-041

Manufactured No

100

Each

5.0000

1



Lid Rib Assembly, Fwd (350 Basket)



⑥

SAD 11-06-22

Location

Loc Qty

Loc Code

WA006

5

69727

5

D4035-043

Manufactured No

100

Each

1.0000

1



Lid Rib Assembly, Aft (350 Basket)



⑦

SAD 11-06-22

Location

Loc Qty

Loc Code

WA006

1

67375

1

D2581

Manufactured No

100

Each

66.0000

2



Mounting Bracket



⑧

SAD 11-06-22

Location

Loc Qty

Loc Code

WA

66

68964

4

69258

28

69739

34

⑨

Tuesday, June 21, 2011 2:34:21 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, June 21, 2011 2:34:21 PM

Page 3

Work Order ID: 71069

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 6/21/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-7

Manufactured No

100 Each

1.0000 1 1



Mesh (350 Basket Short, Lid)

B71114

①

11.06.23

Location

Loc Qty

Loc Code

FG

1

68523

1

D4021-3

Manufactured No

100 Each

4.0000 1 1



Data Plate



SAO 11-06-22

Location

Loc Qty

Loc Code

WA005

4

70240

4

D2728-3

Manufactured No

140 Each

0.0000 1 1



Dart Logo label



115050

B69724 → ①

11-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

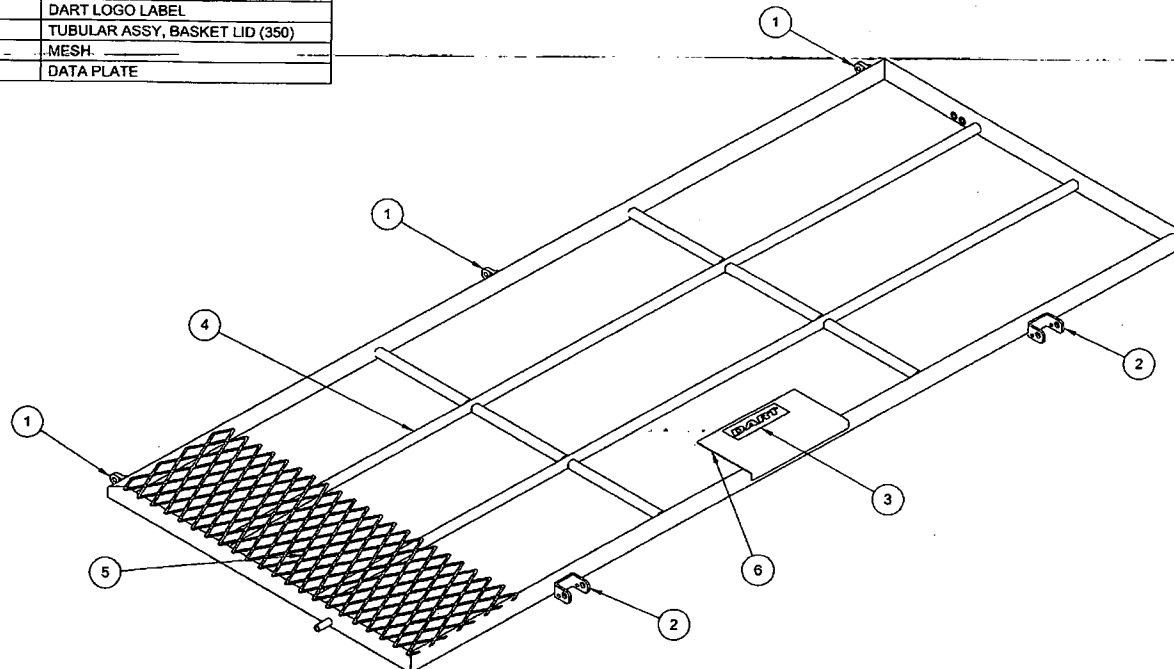
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71069

DP11-06-21

RELEASED
10.08.12
ECIS 10-916

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY: 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C8-2). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4018 REV. C SHEET 1 OF 4 TITLE SHORT BASKET LID ASSY (350) NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>		
MFG. APPR.	<i>SC</i>		
APPROVED	<i>SC</i>		
DE APPR.	<i>SC</i>		
DATE	10.08.05		

W/O:		WORK ORDER CHANGES					
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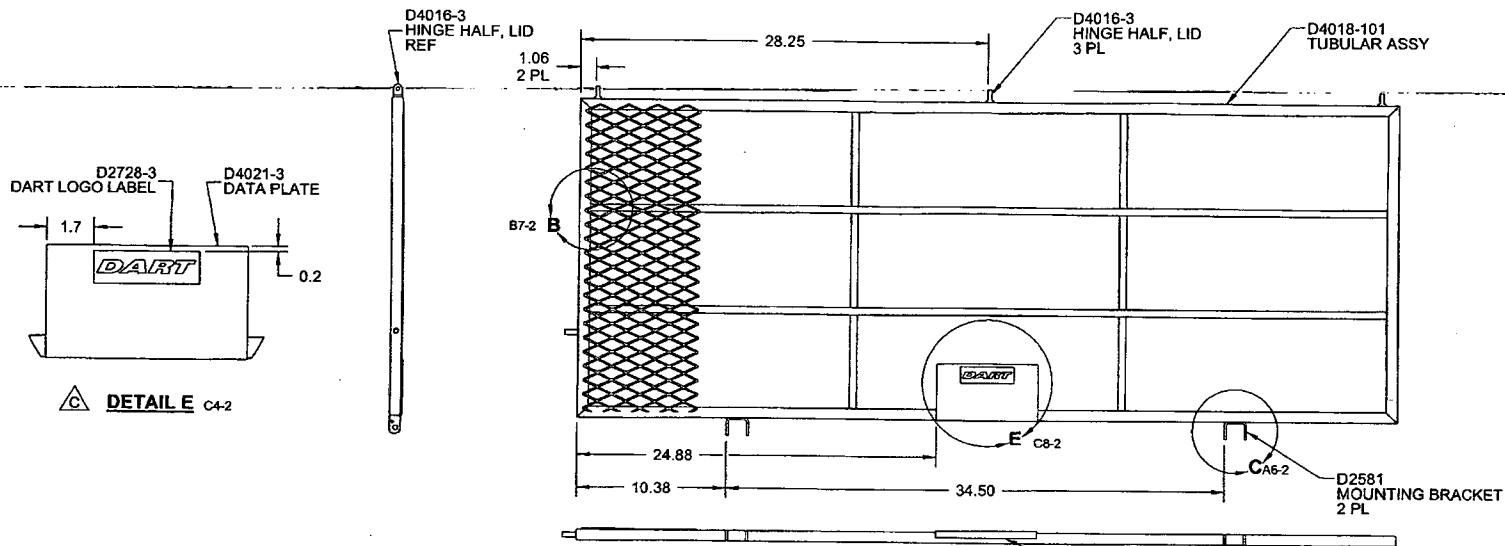
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

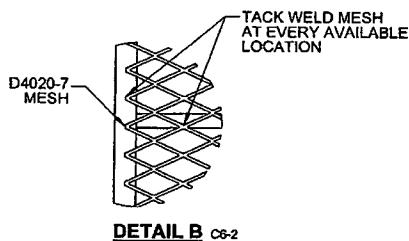
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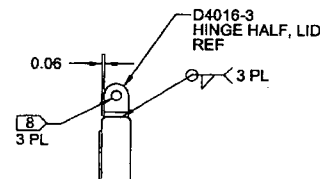
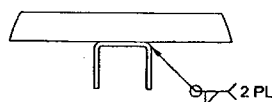
71069



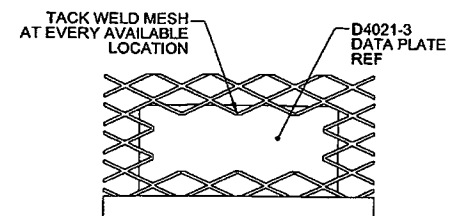
DETAIL E C4-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	MD	D4018	SHEET 2 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY BASIS OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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71069



RELEASED
10.08.12 UP

1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 9.06 lbs
8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
9) WELD PER DART QSI 004

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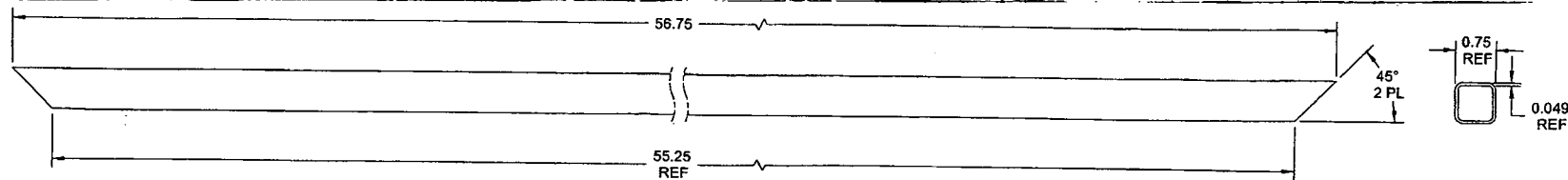
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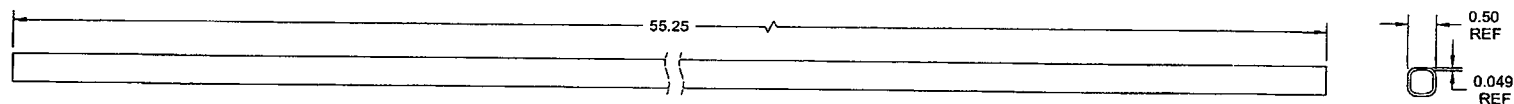
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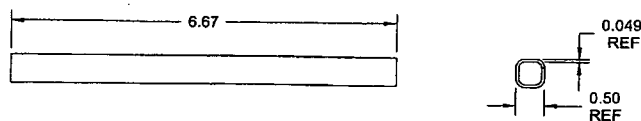
71068



D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

RELEASED
10.08.05

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	A15	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO.	REV. C
MFG. APPR.	h	D4018	SHEET 4 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	SHORT BASKET LID ASSY (350)	NTS
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